Page 1

Wednesday, August 24, 2011 9:02:25 AM

Item ID:

D3272-1

Setup Start

Stop

Revision ID:

Item Name: **Start Date:**

Step

QC:

8/24/2011

Start Qty: 10.00 Req'd Qty: 10.00



Reference:

Approvals:

Date: Date:

Tooling:

SPC (Y/N):

Date: Date:

Run

Sequence ID/ **Work Center ID** Operation Description

Set Up/ **Run Hours** Tool ID

Tool #

Accept Oty

Reject Qty

Reject Number

Insp. Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

Large Fab Large Fab

Large Fab

SQUARE ONE END BEFORE CUTTING OTHER END

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting

table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

QC6- Inspect dimensions to drawing

110

Memo

0.00

and uloghic

0.00

Quality Control

Required Date: 9/30/2011

Accept

Cust Item ID:

Customer:

Plan

Code

Start

Stop

100

Memo

0.00

0.00

Le 11.09.16

W/O:			WORK ORDER	CHANGES				
DATE STEP		PR	OCEDURE CHANGE	Ву	Date	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			·					
								
		Walter State of Control of Contro						
Part No: PAR #:		PAR #:	Fault Category:	NCR: Ye	s No DQ	A :	Date:	
):	Disposition:	QA: N/C Closed:			Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Corrective Action Section B		Description of NC	Corrective Action Section B			Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Initial Action Description Sign &		Section C	Chief Eng	QC Inspector		
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								:		
		· · · · · · · · · · · · · · · · · · ·								

Work Order ID 73028

Wednesday, August 24, 2011 9:02:25 AM



Page 2

Item ID:

D3272-1

Accept



Setup Start

Stop



Revision ID:

Item Name: **Start Date:**

Step

8/24/2011

Start Qty: 10.00 Req'd Qty: 10.00

Cust Item ID:

Customer:

Tool ID

Reference:

Process Plan: **Approvals:**

Tooling:

Date:

Run Start

Oty

Required Date: 9/30/2011

Date:

Date:

SPC (Y/N):

Date:

Tool # Plan

Code

Stop

Sequence ID/ **Work Center ID**

120

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

Memo

Set Up/ **Run Hours**

0.00

0.00

Accept

Qty

Reject Reject Insp. Number Stamp

Packaging

130

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

MF 09-22

	•									
W/O:			V	VORK ORDER CHANG	ES					
DATE STEP		PROC	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
										
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Ye	s No De	 QA:	Date:		
			Disposition: QA: N/C Clo				osed: Date:			
NCR:		W	WORK ORDER NON-CONFO		MANCE (NCR)					
DATE	STEP			Corrective Action Section Action Description Chief Eng	Sign & Date		fication ction C	Approval Chief Eng	Approval QC Inspector	
			Office Ling	Officer Eng.	Ju					
									• • •	
			,							

Picklist Print

Wednesday, August 24, 2011 9:02:22 AM

Work Order ID: 73028

Parent Item:

D3272-1

Parent Item Name: Step



Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A

New Issue 07-06-09

Manufactured

JLM

Component Item	ID/
Item Name	

Replacement Mfg/ Item ID

Purch

Primary Bin Item Location

WA

Last Location

Route Seq ID Unit of

Measure Hand

Qty on Qty per Kit Total

Qty

Qty Issued

Date Status Issued

Page 1

No

100

Each

74.7000

10

D2622-120C

Step Extrusion

<u>Location</u>	Loc Qty	Loc Code
HALL	65	

64409 6 59 682<u>93</u> 9.7 46910 2

66970 7.7

W/O:		WORK ORDER CHANGES								
DATE	STEP	PR	PROCEDURE CHANGE			Date	ate Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto	
Part No	:	PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	Date: _		
	Resolution:		Disposition:	QA: I	WC C	losed:		Date: _		
NCR:		. 1.44	WORK ORDER NON-CON	FORMANCE	(NC	R)				
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC	Corrective Action Section B			Verification	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector			
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	1 1										



-	DESIG	P	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CANA	
	CHEC	SED _	APPROVED	DRAWING NO.	REV. B
	८	E	1	D3272	SHEET 1 OF 3
	DATE			TITLE	SCALE
	07.0	5.18		STEP ASSEMBLY, HI LONG	NTS
	Α		04.03.01	NEW ISSUE	
	В		07.05.18	D3272-1 WAS D2622-120	

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
Х		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	Х	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1 POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

Wlo 73028

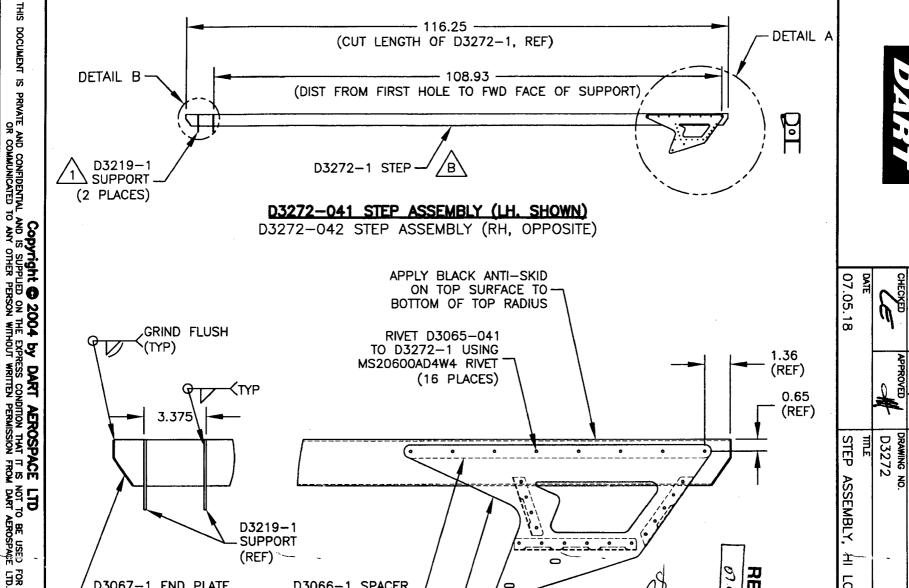
		— - 							
W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							<u> </u>		
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
				1:	QA: N/C Closed: Date:				
NCR:			WORK ORDI	R NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC	Corrective Action Section I Initial Action Description Chief Eng Chief Eng		Ciama D		/erification Section C Approval Chief Eng		Approval
DATE	SIEP	Section A							QC Inspector
	1		1		1	l .			I

RT AERIOSPACE L

SHEET

2 OF 3 SCALE 1:20

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PURPOSE

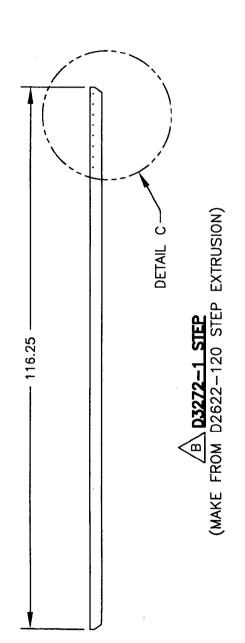
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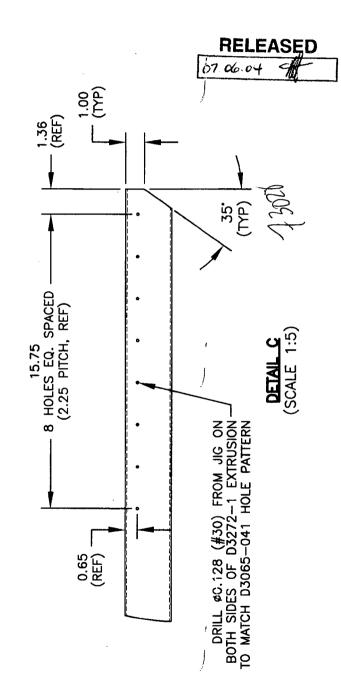
(TYP) 3.375	TO D3272-1 USING MS20600AD4W4 RIVET (16 PLACES)	1.36 (REF) 0.65 (REF)
D3219- SUPPOR (REF) C D3067-1 END PLATE (2 PLACES)	रा / / हिन्हें	RELEAS
DETAIL B (SCALE 1:5)	D3065-041_/ DETAIL A LEG ASSEMBLY (SCALE 1:5)	SED

	1	- -								
W/O:			V	VORK ORDER CHAI	NGES					
DATE	STEP	PROCEDURE CHANGE			-	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Ca	tegory:	NCI	R: Yes I	No DQ	\:	Date:	
			Disposition:							
NCR:			WORK OR	DER NON-CONFOR	MANCE	(NCR)			
DATE	STEP	Description of NC	Corrective Action Section					ation	Approval	Approval
	J.L.	Section A	Initial Chief Eng	Action Descriptio	on .	Sign & Date	Section C		Chief Eng	QC Inspector
					:					
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ſ	DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHECKED	APPROVED	DRAWING NO. D3272	REV. B SHEET 3 OF 3				
İ	DATE		TITLE	SCALE				
	07.05.18		STEP ASSEMBLY, HI LONG	1:20				





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		V	ORK ORDER CHANG	ES					
STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		•							
:	PAR #:	Fault Ca	tegory:	NCR	: Yes N	lo DQ	A:	Date:	
								Date:	
		WORK OR	DER NON-CONFORMA	ANCE	(NCR))			
STEP	STEP Description of NC Section A					Verification		Approval	Approval
		Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section C	Chief Eng	QC Inspector	
	·								
							<u> </u>		
	R	:PAR #: Resolution:	STEP PROCEDURE CHECK PAR #: Fault Care Resolution: Disposit WORK ORI STEP Description of NC Section A Initial	STEP PROCEDURE CHANGE :PAR #:Fault Category: Resolution:Disposition: WORK ORDER NON-CONFORM STEP Description of NC Section A Section A Section A Action Description	PAR #: Fault Category: NCR Resolution: Disposition: QA: WORK ORDER NON-CONFORMANCE STEP Description of NC Corrective Action Section B Section A Initial Action Description	STEP PROCEDURE CHANGE By PAR #: Fault Category: NCR: Yes N Resolution: Disposition: QA: N/C Clo WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Corrective Action Section B Initial Action Description Sign &	STEP PROCEDURE CHANGE By Date PAR #: Fault Category: NCR: Yes No DQ/ Resolution: Disposition: QA: N/C Closed: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A	STEP PROCEDURE CHANGE By Date Qty	STEP PROCEDURE CHANGE By Date Qty Chief Eng / Prod Mgr :PAR #: Fault Category: NCR: Yes No DQA: Date: Resolution: Disposition: QA: N/C Closed: Date: WORK ORDER NON-CONFORMANCE (NCR) STEP Description of NC Section A Corrective Action Section B Section C Section C Chief Eng Chief